Work Orde Wednesday, Jani											Page 1
Revision ID:	D3240-1 Frame			Accept			<b>1441 1441 1111</b>	Setup	Start Stop		
	1/26/2011 2/4/2011	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item II Customer:	D:				( ( <b>( ( ( ( ( ( ( ( ( ( ( ( ( ( ( ( ( </b>	
Approvals:	Process Plan	n:	Date//-0/- 20			ite:		Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description	111-111-11-11-11-11-11-11-11-11-11-11-1	Set Up/ Run Hours	Tool ID	Tool # Pla		t Rej Qty		•	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3240	Rev	В									
Waterjet FLOW CNC Waterje			per Dwg D3240 □Dwg Re `necessary	0.00 0.00 ev: □ Prog Rev:	<u>B</u> □2-		<u> </u>	<u> </u>	<u>.                                    </u>	<u></u>	
110 		QC2- Inspect parts of	f machine FAI/FAIB	0.00				_			
QC Quality Control		Memo		0.00			<u> </u>	H - 3-	-4		· ·

QC8- Inspect parts - second check

0.00

Memo

40 Sularly

Quality Control

Dart Aeı	rospace	Ltd					•	
W/O:			WOF	RK ORDER CHANGES				<b>!</b>
DATE	STEP	PRO	OCEDURE CHANG	GE .	. By	Date Oty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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****								
Part No	:	PAR #:	Fault Catego	ry: N	ICR: Yes 1	No DQA:	Date: _	
	R	esolution:	Disposition:	G	A: N/C Clo	sed:	Date: _	
NCR:			WORK ORDER	R NON-CONFORMANO	CE (NCR)			
		Description of NC	C	orrective Action Section B		Verification	n Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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	T			Corrective Action Section B				
DATE	STEP	<b>Description of NC</b> Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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#### Work Order ID 65871

Wednesday, January 26, 2011 1:48:08 PM



Page 2

Item ID:

D3240-1

Accept



Setup Start



**Revision ID:** 

**Start Date:** 

Item Name:

Frame

1/26/2011

Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date:

Tooling:

Date:

Run Start

Reject

Qty



Required Date: 2/4/2011

QC: \_\_\_\_\_ Date:

SPC (Y/N):

Set Up/

Date:

Tool#

Plan

Code

Accept

Qty

Stop

Reject

Number

Stop

Insp.

Stamp

Sequence ID/ **Work Center ID** 

130

Small Fab

Small Fab

Operation Description

Small Fab

**Run Hours** 0.00

0.00

140

HandFinish

Hand Finishing

Chemical Conversion Coat per OSI005 4.1

0.00

Memo

0.00

H BR 11-3-8.

150

QC3- Inspect Part Finish

Memo

0.00

0.00

4 & M 1103/09

Quality Control

## **Dart Aerospace Ltd**

W/O:			W	ORK ORDER CHANG	ES				r
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No D	QA:	Date: _	
	R	esolution:	Dispositio	n:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (NO	CR)	• • • • • • • • • • • • • • • • • • • •		
DATE	STEP	Description of NC			ion B	Veri	fication	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig: Da		ection C	Chief Eng	QC Inspector
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#### Work Order ID 65871

Wednesday, January 26, 2011 1:48:08 PM



Page 3

Item ID:

D3240-1

Accept

Setup Start

Revision ID: Item Name:

Frame

Start Oty: 4.00

**Cust Item ID:** 

Stop

Start Date:

1/26/2011 Required Date: 2/4/2011

Rea'd Otv: 4.00

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start Run



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location 2/4

Memo

0.00 0.00 Tool ID

Tool # Plan Code

Accept Qty

Reject Reject

Insp. Number Stamp

170

QC Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

11/03/09 H

## Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANG	ES				ē
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _	
	Res	solution:	Disposition	n:	_ QA: N/C Clo	osed:		Date:	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
!									
i									

# **Picklist Print**

Wednesday, January 26, 2011 1:48:14 PM

Work Order ID: 65871

D3240-1 Parent Item:

Parent Item Name: Frame



Start Date: 1/26/2011

Required Date: 2/4/2011

Start Qty: 4.00

Required Qty: 4.00

$C_{\mathbf{f}}$	m	m	۸n	tc.	

IPP B□05.04.28□Added Step 6 & 7□KJ/JLM□

IPP Rev C now water jet 07-11-01 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
		Purchased	No			110	sf	55.9270	2.534	10.66947 H3	11-3-4			_
2024-T3 .063 sheet				Location	1	Loc	Otv	Loc Code				: 121:		

MAT22 55.927 GIOTH 114351 55.927 BIOCH

Page 1

# **Dart Aerospace Ltd**

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W/O:			WO	RK ORDER CHAN	GES					ř.
DATE	STEP	PRO	OCEDURE CHAI	NGE		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
····										
Part No	:	PAR #:	Fault Cated	gory:	NCR:	Yes N	lo <b>DQ</b>	<b>A</b> :	_ Date: _	<del></del>
	Re	solution:							Date: _	
NCR:		,	WORK ORD	ER NON-CONFORM	MANCE (	NCR)				
DATE	STEP	Description of NC			ection B	Ciam 0		cation	Approval	Approval
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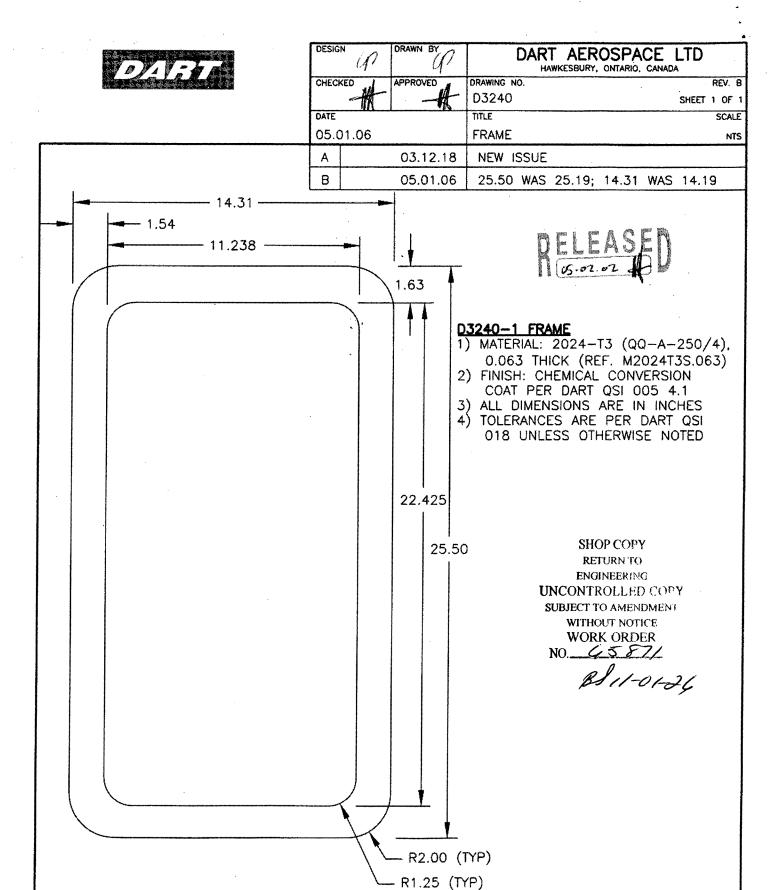
DART AEROSPACE LTD	Work Order:	65871
Description: Frame	Part Number:	D3240-1
Inspection Dwg: D3240 Rev: B		Page 1 of 1

	FIRST	ARTICLE INS	PECTION	N CHECK	KLIST		
	X	First Article	e	Prototy	pe		•
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	С	omments
25.50	+/-0.030	25.50	+		T 1801		
22.425	+/-0.010	764.66	×		+	_	
1.63	+/-0.030	1.636	8		V 1802		
14.31	+/-0.030	14.31	X		7		
11.238	+/-0.010	11.738	y		7		
1.54	+/-0.030	1,534	Ç,		V		
0.063	+/-0.010	5003	×		V		
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-							-
easured by:		Audited by: S		Pr	ototype Appro	val:	N/A
- 14	-3-4		Jalu			ate:	N/A
	Change L		1/03/4		Revised	1	Approved

Wieas	ureu by.	₩.	Addited by.	Prototype Approvat.	IN/A
	Date:	11-3-4	Date: 11/03/4	Date:	N/A
Rev	Date	Change	•	Revised by	Approved
Α	07.11.23	New Issue		KJ/EC/DD	1 1
				70	

Dart Aerospac	e Ltd
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W/O:		WORK ORDER CHANGES  Approval Approval									
DATE	STEP	STEP PROCEDURE CHANGE			Ву	Date	Qty	Chief Eng / Prod Mgr	Approval QC Inspector		
	;										
Part No	•	PAR #:	Fault Cateo	Orv:	NCR: Ves	No DO	Δ.	Date			
rait NO				QA: N/C Closed: Da							
r	יח							Date			
NCR:		<b>\</b>	WORK ORDE	R NON-CONFORMA	INCE (NCF	1)					
DATE	STEP	Description of NC Section A	Corrective Action Sect			Verifi	cation	Approval	Approval		
			Initial Chief Eng	Action Description Chief Eng	Sign & Date	k Sect	tion C	Chief Eng	QC Inspector		
		}									
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W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Categ	_ NCR: Ye	s No DQ	DQA: Date:			
Resolution:			Disposition	_ QA: N/C	QA: N/C Closed:			Date:	
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC Section A	Corrective Action S Initial Action Description		ion B		ication tion C	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng	Da			Office Eng	QO IIISPOOLOI